



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5354-042
Job Sheet 185725



Part No: D5354-042

Job Qty: 4 ea

Part Name: R66 Fwd Clamp Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 2,4 IPP REV.A New issue 16/07/08 JFS Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Machining-4		18-12-11
100	Bandsaw	4 pcs	11/16/18	11/16/18	0.00	0.01	Bandsaw1		19-04-21
110	CNC Vertical Machining	4 pcs	11/16/18	11/16/18	0.00	9.30	HAAS1-2		19-04-21
120	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Machining-4		19/04/23
130	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC8 Machining-4		APR 30 2019
140	Outsource	4 pcs	11/16/18	11/16/18			GRO002-VC	10	MAY 01 2019
150	Packaging	4 pcs	11/16/18	11/16/18	0.00	0.00	Packaging2		MAY 02 2019
155	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC6		MAY 02 2019
160	Small Fab	4 pcs	11/16/18	11/16/18	0.00	1.83	Small Fab-9		MAY 02 2019
170	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC5		MAY 02 2019
180	Packaging	4 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-2		MAY 02 2019
190	QC21-SA	4 Ea	11/16/18	11/16/18	0.00	0.00	QC21		MAY 02 2019

Part Op 100 - Cut Blanks at 4.250"

Descriptions: 110 - 1-Machine per folio FB436 (D5354-2) DWG REV: C FOLIO REV: AA 2- deburr and break all sharp edge as per dwg

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Outsource process-Anodize per QSI017 4.1.10.1

150 - Receive & Inspect for Damage & Mat'l Certs

155 - QC5- Inspect part completeness to step on W/O

160 - Assemble as per dwg. -Secure nuts as per dwg. (Note #8) -Apply proseal as per dwg. (Note #9)

Batch: _____ Exp. date: _____

170 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X4.500	6061-T6 Bar 1.25 X 4.50	1.4160 ft (.354 ea)	90-Start up Operation	5136 830
D5316-1	T-Bolt Strap	8 Ea (1 ea)	160-Small Fab	5137 487 X3 345 896 X5
D5351-1	T-Bolt Spacer	16 Ea (2 ea)	160-Small Fab	5142 106
MS21043-3	Nut	16 Ea (2 ea)	160-Small Fab	5149 144
				5167 289

Job Allocations

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Suspect ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:							
Description Work Order Deviation									
				MRB (QSI042) Approval					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/l	☐	Power Loss/Surge	☐
Design	☐	Operator	☐	Bending	☐	Folio/Program	☐
Doc/Data	☐	Offset/Setup	☐	Centre Nc	☐	Grain	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Weld	☐
Handling/Pre	☐	Training	☐	Crimp/Kir	☐	Wrong Stock Pulled	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐
Tribal Knowledge	☐	Rushing	☐	Heat Trea	☐	Mislabeled	☐
LOA	☐	Product Improvement	☐	Wave/Tw	☐	Fit/Function	☐
Substation	☐	Process Improvement	☐	Marks/Ch	☐	Misaligned/off center	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :	☐	Positioned Wrong	☐
Misidentified	☐	Past Due	☐		☐	Outside Dimensions	☐
					☐	Over/Under tolerance	☐
					☐	Part Incorrect	☐
					☐	Part Lost/Missing	☐
					☐	Part Moved	☐
					☐	Drawing	☐
					☐	Finish	☐
					☐	Misread	☐
					☐	Turning Sequence	☐

Date: 12/11/18
 Instructions: Various STC's
 Exp Date:
 Inspector:
 Revision:
 Serial No/ Batch: S136832
 Job No: 185725
 Part: D5354-042
 Container No: S136832

DART AEROSPACE
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.250X4.500	1	4	0
160-Small Fab	D5316-1	4	11	0
	D5351-1	8	51	0
	MS21043-3	8	1,010	0
	NAS1149D0332J	2		
Part Specifications				
Specifications could not be found.				

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	185725
Description: Support, RH		Part Number:	D5354-2
Inspection Dwg: D5354 Rev: B		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	0.502	✓		Vern	GA-13
Ø0.204	+0.005/-0.001	Ø0.203	✓		"	"
0.20	+/-0.030	0.200	✓		"	"
0.279	+/-0.010	0.275	✓		"	"
Ø0.257	+0.005/-0.001	Ø0.258	✓		"	"
1.28	+/-0.030	1.275	✓		H-6	31006
0.13	+/-0.030	0.124	✓		Mic	GA-03
R0.25	+/-0.030	R0.250	✓		R-6	ref.
1.000	+/-0.005	1.000	✓		H-6	31006
1.67	+/-0.030	1.670	✓		Vern	GA-13
0.31	+/-0.030	0.311	✓		"	"
0.50	+/-0.030	0.499	✓		"	"
0.500	+/-0.005	0.500	✓		H-6	31006
0.15	+/-0.030	0.150	✓		Vern	GA-13
0.13	+/-0.030	0.125	✓		Mic	GA-03
3.40	+/-0.030	3.394	✓		H-6	31006
R0.13	+/-0.030	R0.125	✓		R-6	ref.
0.25	+/-0.030	0.249	✓		Vern	GA-13
1.00	+/-0.030	1.003	✓		"	"
94.8°	+/-0.5°	94.8°	✓		Dial ind.	HAAS5axis / ref.
0.25	+/-0.030	0.252	✓		Vern	GA-13
0.150	+0.015/-0.000	0.154	✓		Mic	118-120
0.250	+/-0.015	0.2475	✓		D-6	GA-08
0.65	+/-0.030	0.649	✓		Mic	GA-03
R0.20	+/-0.030	R0.200	✓		G-P	ref.
R0.13	+/-0.030	R0.125	✓		R-6	ref.
R0.25	+/-0.030	R0.250	✓		"	"
3.06	+/-0.030	3.055	✓		Vern	GA-13
0.40	+/-0.030	0.395	✓		"	"
0.13	+/-0.030	0.133	✓		"	"
0.14	+/-0.030	0.142	✓		"	"
0.30	+/-0.030	0.307	✓		Mic	118-120

Measured by:	B-a	Checked by:	gmk	QC Inspector:	
Date:	19-04-21	Date:	19/04/23	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043301



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043301
PO Date: 4/25/19
Due Date: 5/1/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185725	D5354-042	R66 Fwd Clamp Assembly, RH : Various STC's Outsource process-Anodize per QSI017 4.1.10.1 Anodize Black Per MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS2	Firmed	-	5/1/19	8 pcs	0 pcs	8 pcs	\$15.00/pcs	\$120.00
Grand Total:											\$120.00

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Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/29/19 8:26 AM dart.Lussier.Patrick

**Certificat de Conformité / Certificate of Compliance**
(018763-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupealtech.com

Bon de Livraison / Packing Slip**018763- 1**

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
29-Apr-2019		Jessie Boisvert			POHB043301			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	D5354-042 Rev.	D5354-042 ANODIZE BLACK PER MIL-A-8325F TYPE I OR IB OR IC OR II OR IIB CLASS 2	ANODIZE CH	8	8	0	0	0

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Actual Thickness**Inspecteur Qualité**
Quality Inspector**Réçu par**
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.